

Work Order ID 64997

Wednesday, January 05, 2011 1:16:37 PM



Page 1

Item ID: D3655-1

Accept



Setup Start



Revision ID:

Item Name: PANEL

Stop



Start Date: 1/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 1/01/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3655	Rev B								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3655 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B11-1-6

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-1-6

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S. 1/01/06

(X2)

4/5/11/01/06

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Required Date: 1/14/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location <u>241A</u> Memo	0.00 0.00				10/1/6	5	20	
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				OK	11/01/07		

MF
11-06-01

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Picklist Print

Wednesday, January 05, 2011 1:16:41 PM

Page 1

Work Order ID: 64997

Parent Item: D3655-1

Parent Item Name: PANEL



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ext. Rev. A 07/12/13
IPP Rev:B 08-03-06 prototype DD verified by:EC
IPP Rev:C 08-04-07 revA DD verified by:EC
IPP Rev. D 08/08/16 Dwg. Update. DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,824.630	3.5366	7.445474			
GE PLASTICS LEXAN SHEET													

Location

Loc Qty

Loc Code

therm

1824.63

107574

6.46

112176

101.2267

114459

1716.9433

B11-1-6

114459

2

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DART AEROSPACE LTD		Work Order: 64927
Description: Panel		Part Number: D3655-1
Inspection Dwg: D3655	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.94	+/-0.030	1.94	X		T RB 01	
3.81	+/-0.030	3.81	X		T	
5.63	+/-0.030	5.63	X		T	
15.69	+/-0.030	15.69	X		T	
15.75	+/-0.030	15.75	X		T	
17.88	+/-0.030	17.88	X		T	
17.94	+/-0.030	17.94	X		T	
31.50	+/-0.030	31.50	X		T	
33.63	+/-0.030	33.63	X		T	
47.25	+/-0.030	47.25	X		T	
47.19	+/-0.030	47.19	X		T	
49.38	+/-0.030	49.38	X		T	
49.44	+/-0.030	49.44	X		T	
59.50	+/-0.030	59.50	X		T	
61.31	+/-0.030	61.31	X		T	
63.19	+/-0.030	63.19	X		T	
65.06	+/-0.030	65.06	X		T	
65.13	+/-0.030	65.13	X		T	
65.94	+/-0.030	65.94	X		T	
2.75	+/-0.030	2.75	X		T	
5.75	+/-0.030	5.75	X		T	
5.88	+/-0.030	5.88	X		T	
7.63	+/-0.030	7.63	X		T	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-1-06	Date: 11/01/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	

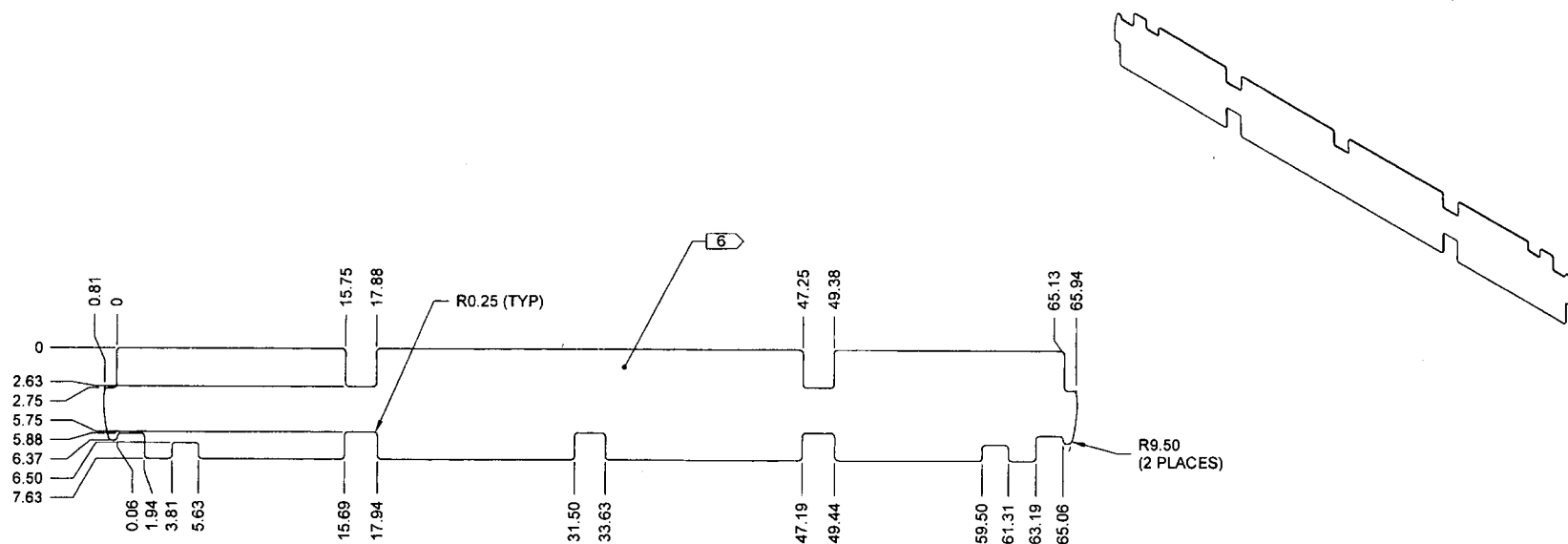
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D3655-1 PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *04997*

RELEASED
08 07 30 14

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.9 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D6-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	08.06.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3655 TITLE PANEL REV. B SHEET 1 OF 2 SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

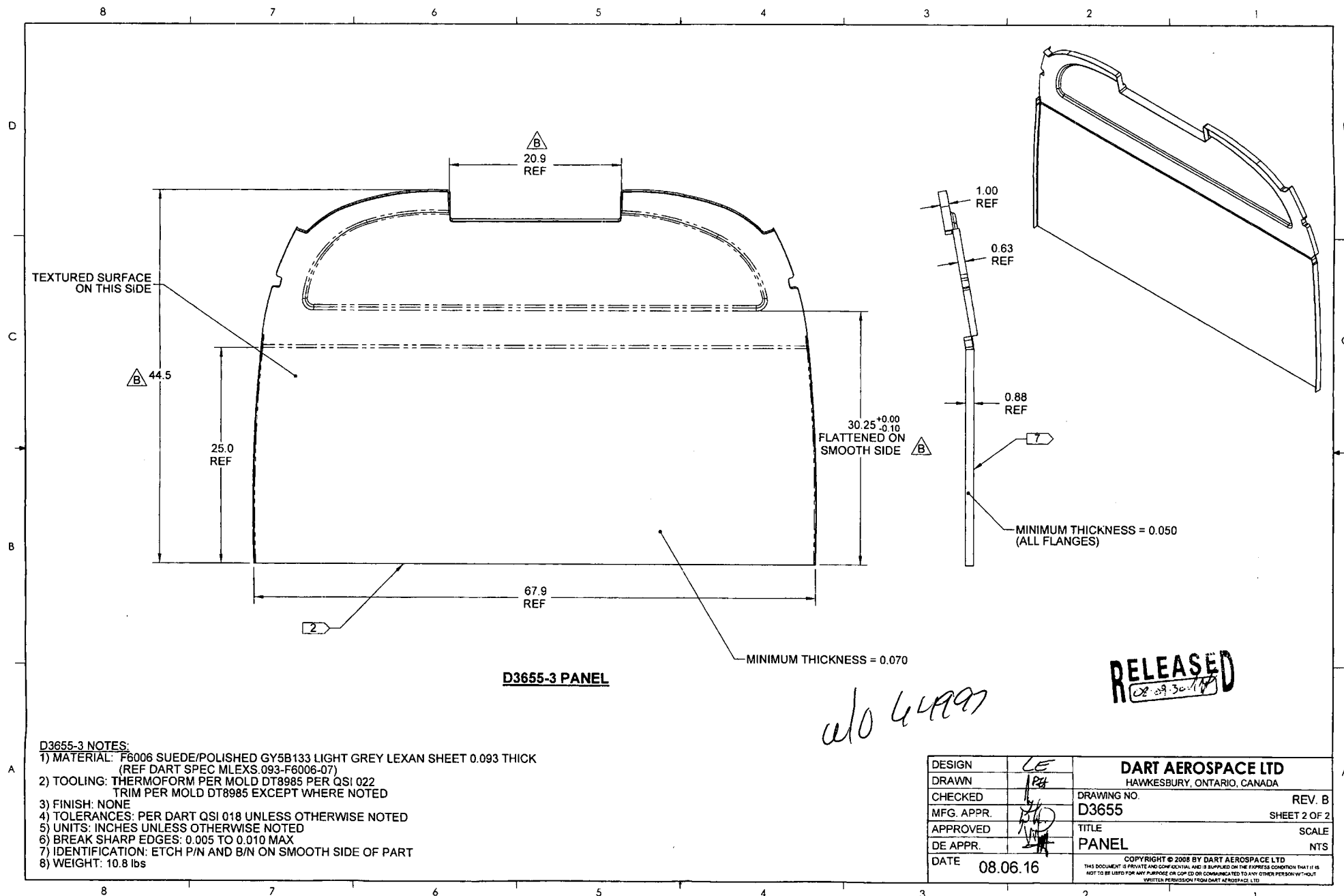
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